



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-3
Job Sheet 178400



Part No: SWA6A-3

Job Qty: 1 ea

Part Name: Electric Swivel 6,000 lb Safe Work Load (2,721 Kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA6A Rev. 4 IPP Rev. A 18.05.14 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/31/18	5/31/18	0.00	0.00	Start Up Small Fab-2		SP
110	Small Fab	1 pcs	5/31/18	5/31/18	0.00	2.00	Small Fab-6	AP	SP
120	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC5		SP
125	DC	1 pcs	5/31/18	5/31/18	0.00	0.00	DC		SP
130	Packaging	1 pcs	5/31/18	5/31/18	0.00	0.00	Packaging3.		SP
140	QC21-FG	1 Ea	5/31/18	5/31/18	0.00	0.00	QC21		SP

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

125 - Photocopy blue file OM & OOPM-SWA6A Rev2

130 - Bag and tag

LOCTITE 242 (M138762) SAF-T-EZ (M128063) GREASE NO.7 AEROSHELL (M138724)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA6A-800B	Connector Bushing	1 Ea (1 ea)	90-Start up Operation	5029420
188-FPSS-1032-1/2	Set Screw	1 Ea (1 ea)	110-Small Fab	5037620
188-FSCS-1032-5/8	Screw	4 Ea (4 ea)	110-Small Fab	5060767
C45-15-13	Sleeve	1 Ea (1 ea)	110-Small Fab	5027232
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5027232
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5054451
EL314-SJTOW	3 Wire	6 ft (6 ea)	110-Small Fab	5047767
SWA6A-100	Lower End	1 Ea (1 ea)	110-Small Fab	5029404
SWA6A-1100	Upper Bearing	1 Ea (1 ea)	110-Small Fab	5040726
SWA6A-1200	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5044600
SWA6A-1300	Lower Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5043315
SWA6A-1400	Circlip Internal	1 Ea (1 ea)	110-Small Fab	5029406
SWA6A-1800	Cover	1 Ea (1 ea)	110-Small Fab	5040978
SWA6A-1900	Female Spade Terminal - 1/4"	6 Ea (6 ea)	110-Small Fab	5054299
SWA6A-200	Upper End	1 Ea (1 ea)	110-Small Fab	5029409
SWA6A-300	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5029411
SWA6A-400	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5029413
SWA6A-500	Semi Rings	1 Ea (1 ea)	110-Small Fab	5029414
SWA6A-600	Collar	1 Ea (1 ea)	110-Small Fab	5029416
SWA6A-700	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5038706
SWA6A-900B	Rotary Contact	1 Ea (1 ea)	110-Small Fab	5045653

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube</td> <td style="border: none;">☐</td> <td style="border: none;">Cross tube</td> <td style="border: none;">☐</td> <td style="border: none;">Water Jet</td> <td style="border: none;">☐</td> <td style="border: none;">Engineering</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Machining</td> <td style="border: none;">☐</td> <td style="border: none;">Small Fab</td> <td style="border: none;">☐</td> <td style="border: none;">Prod. Eng. Coord.</td> <td style="border: none;">☐</td> <td style="border: none;">Quality</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;"></td> <td style="border: none;"></td> <td style="border: none;">Finishing</td> <td style="border: none;">☐</td> <td style="border: none;">Rec/Store/Packaging</td> <td style="border: none;">☐</td> <td style="border: none;">Other</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;"></td> <td style="border: none;"></td> <td style="border: none;">Composite</td> <td style="border: none;">☐</td> <td style="border: none;">Supplier</td> <td style="border: none;">☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> </table>	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐			Finishing	☐	Rec/Store/Packaging	☐	Other	☐			Composite	☐	Supplier	☐																																																																																													
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 110-Small Fab	SWA6A-800B	1	0	0
	188-FPSS-1032-1/2	1	83	0
	188-FSCS-1032-5/8	4	201	0
	C45-15-13	1	12	0
	EL-PLUG-F	1	40	0
	EL-PLUG-M	1	77	0
	EL314-SJTOW	6	926	0
	SWA6A-100	1	2	0
	SWA6A-1100	1	21	0
	SWA6A-1200	1	29	0
	SWA6A-1300	1	11	0
	SWA6A-1400	1	20	0
	SWA6A-1800	1	12	0
	SWA6A-1900	6	280	0
	SWA6A-200	1	1	0
	SWA6A-300	1	0	0
	SWA6A-400	1	1	0
	SWA6A-500	1	1	0
	SWA6A-600	1	1	0
	SWA6A-700	2	19	0
	SWA6A-900B	1	14	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

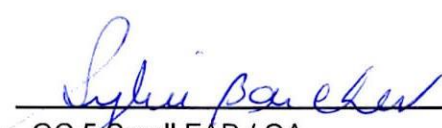
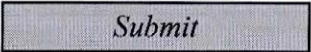
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

Work Order 178400

Customer _____

Number of Wires 3Date 2018/06/04Serial Number S076965

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	6,000	Check for Conductivity against all wires.	- PASS
1	6,000	Check all wires for grounding against swivel body.	- PASS
1	3,000	Check for Conductivity against all wires.	- PASS
1	3,000	Check all wires for grounding against swivel body.	- PASS
1	1,500	Check for Conductivity against all wires.	- PASS
1	1,500	Check all wires for grounding against swivel body.	- PASS
1	0	Check for Conductivity against all wires.	- PASS
1	0	Check all wires for grounding against swivel body.	- PASS

Test Conducted By: ALAN PATRY
TechnicianSignature: 
QC 5 Small FAB / QASubmit